



Dart Hawkesbury
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Canada

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D4634-143
Job Sheet 167077-J



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	D.M.L 18-1-23
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	D.M.L 18-1-23
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.M.L 18-1-23
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	38 JAN 29 2018
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 18-1-31
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-35019746	1	2	0	0
	D4636-55033847	2	43	0	0
	D4647-15033846	1	4	0	0
	D4664-55033844	6	39	0	0
	D4712-15033843	2	4	0	0
	D4732-21 F123210-1	1~	6	0	0
	D4732-25 F123212	1~	7	0	0
	D5021-3 5033841	1	2	0	0
	MPNY-750S-9-C5033638	3	570	0	0
	MS20426AD3-4 5033837	4	5,055	0	0
	MS20426AD4-6 5033836	4	2,797	0	0
	MS21059L08 5033835	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐		Skid-tub	
NCR No. _____		Scrap ☐		Machin	
		Use-as-is ☐		Thermoformin	
		Suspected Unapproved ☐		Large Fa	
Date : _____		Step #: _____		QTY Eff	
MASTER 000037					
Description Work Order Deviation					
DART AEROSPACE S034996 Middle, Center Ceiling Replacement Panel Assembly PART NO: D4634 - 143 Original Serial #: S034996 Revision: Operation: Start up Operation 01/24/18 Change No: Job No: 167077 - J					
Root Cause					
Environment ☐		No Re-verification ☐		Temperature/C	
Design ☐		Operator ☐		Set-up	
Doc/Data ☐		Offset/Setup ☐		BOM/Route	
Equip/Tooling ☐		Supplier ☐		Broken/Damag	
Handling/Pre ☐		Training ☐		Inspection Inco	
Material ☐		Use for Testing ☐		Contamination	
Internal Transport ☐		Poor Information ☐		Countersink	
Tribal Knowledge ☐		Rushing ☐		Cut Too Short	
LOA ☐		Product Improvement ☐		Instructions Inc	
Substation ☐		Process Improvement ☐		Drill Holes	
Past Expiry Date ☐		Manufacturing Process ☐			
Misidentified ☐		Past Due ☐			
		OTHER :			

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Middle, Center Ceiling Replacement Panel Assembly

PART NO: D4634 - 143
Original Serial #: S034996
Revision:
Operation: Start up Operation 01/24/18
Change No: Job No: 167077 - Jg
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approval

By

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Misaligned/off center

turning sequence